



Date: Tuesday, 8/21/2007 9:09:06 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 34115	
Estimate Number : 10839	
P.O. Number : N/A	Part Number : D22491
This Issue : 8/21/2007 S.O. No. : N/A	Drawing Number : D2249 REV. E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 31609A	Material : N/A
Written By : 	Due Date : 8/24/2007
Checked & Approved By : 	Qty : 40 Um : Each
Comment : Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0903 sf(s)/Unit Total : 3.6120 sf(s)
 304/316 .063 Sheet
 Batch: M109130

SAD 07/08/21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2249
 Dwg Rev: E
 Prog Rev: E

2-Deburr if necessary

SAD 07/08/21

42

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/21

42

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/08/21

Cauter

(42)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: U510

FC 07/08/23

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 09/08/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 9:09:06 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34115

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

42
1257108124

Job Completion



12 8.28.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

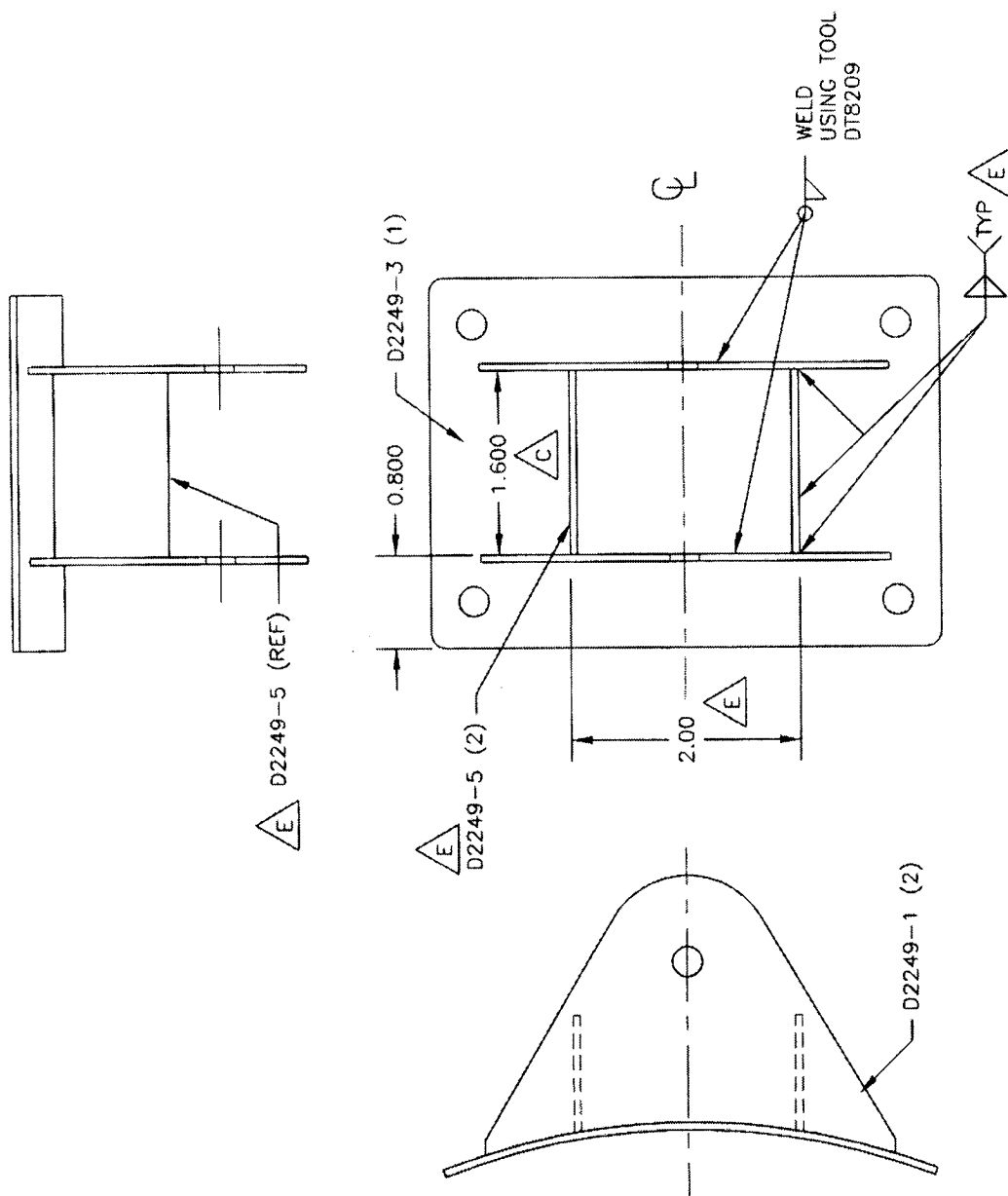
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
99.10.12 KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2249	REV. E SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



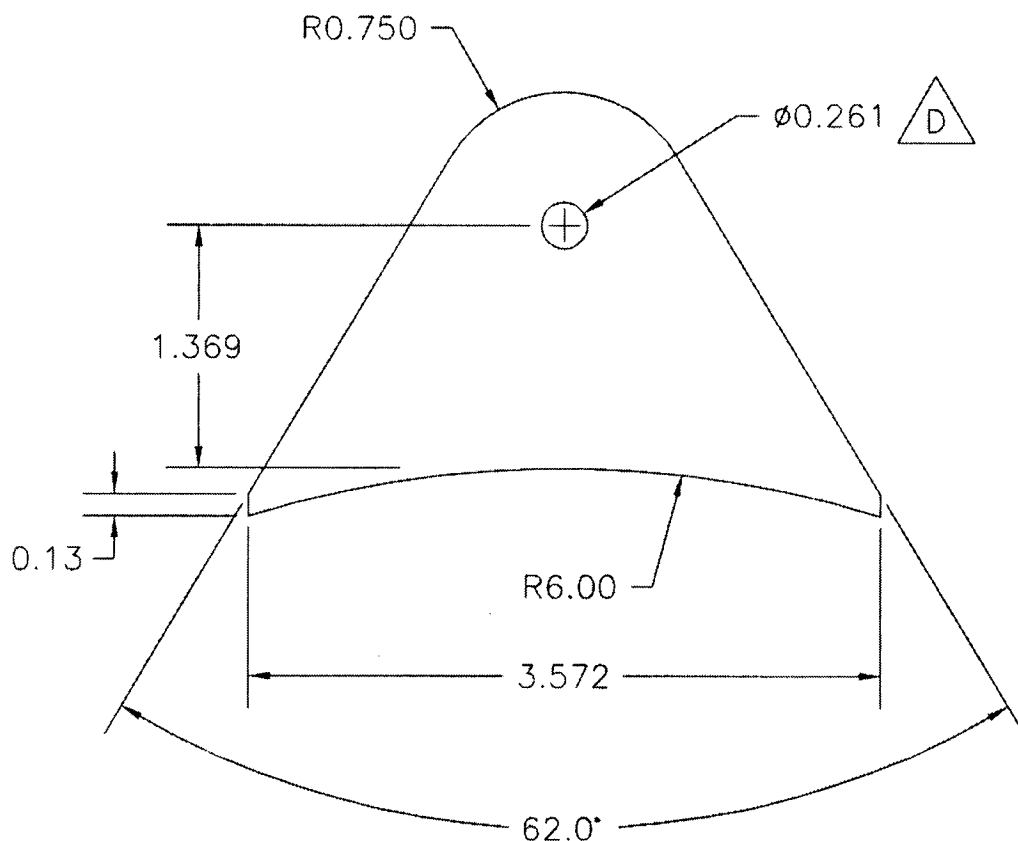
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



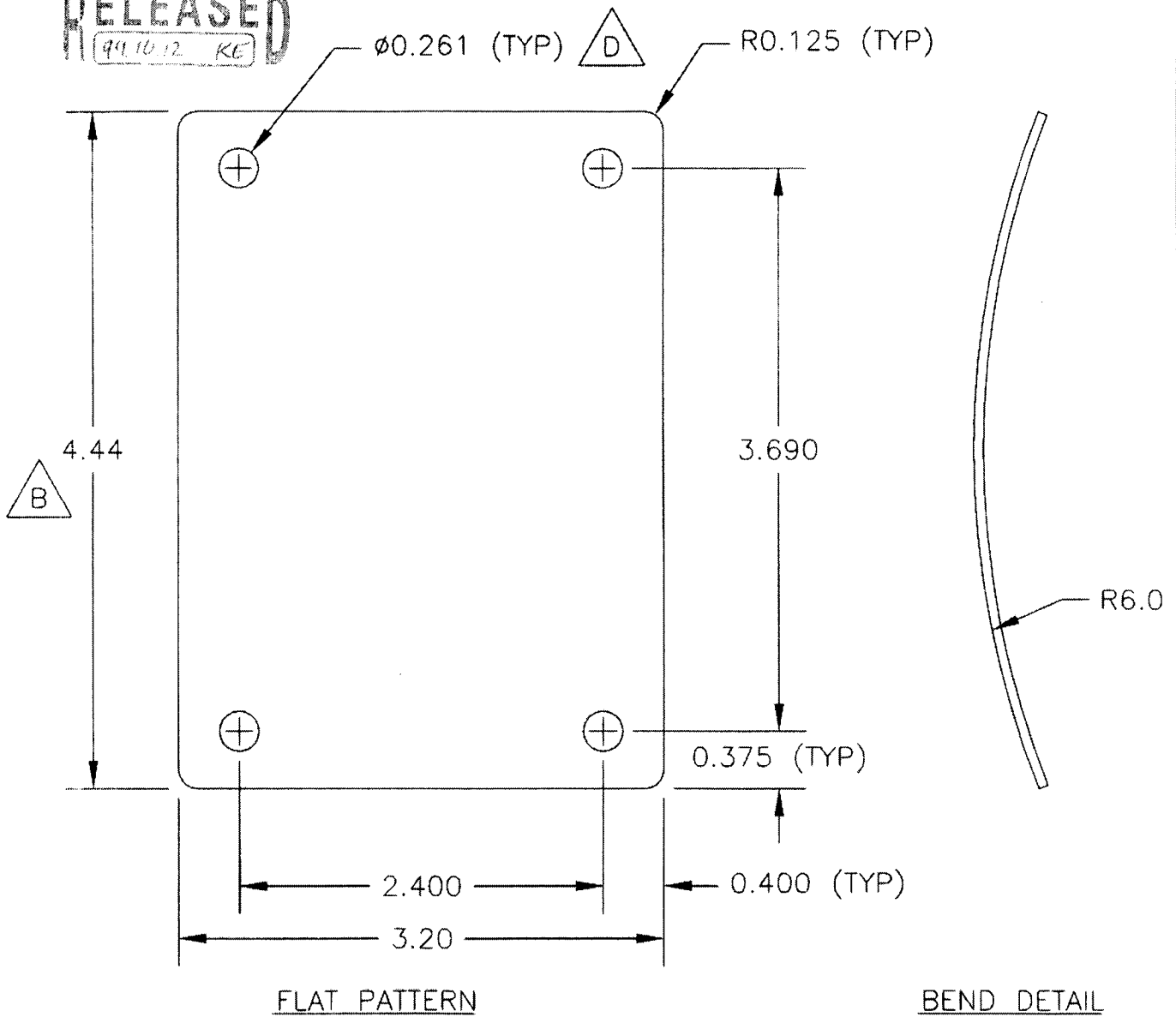
D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



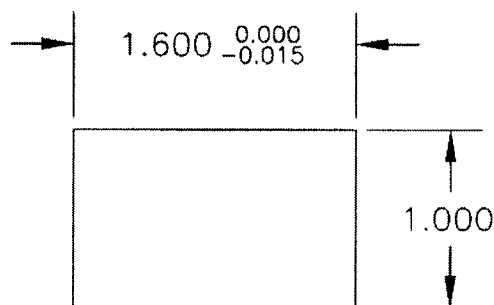
D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>TH</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
19.10.12 *KE*



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

